

Date: Tuesday, 5/23/2006 8:31:58 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
Job Number : 27194 ✓ Estimate Number : 12403
P.O. Number : N/A Part Number : D3511041
This Issue : 5/23/2006 S.O. No. : N/A Drawing Number : D3511 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
Previous Run : 27006 Material : N/A
Due Date : 6/10/2006 Qty: 20 Um: Each
Written By : SEE COMMENT BELOW
Checked & Approved By : M 06 05 23
Comment : Est Rev:A New Issue 06-05-04 JLM
Est Rev:B New process 06-05-05 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S188 304 SHEET .188" THICK



Comment: Qty.: 1.5572 sf(s)/Unit Total : 31.1430 sf(s)
304 SHEET .188" THICK
(M304S0188)
Batch: M 06 05 29 (6)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3511
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary
Identify as D3511-1

M 06 05 29 (6)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 05 29 (6)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M 06 05 29 (6)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27194

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35031

CUP



Comment: Qty.: 8.0000 Each(s)/Unit Total: 160.0000 Each(s)

CUP

Batch: 627198MOG/05/29

⑥

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

2-Bend fwd 90 deg. bend per dwg D3511

MOG/05/29 ⑥

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch: M/00372MOG/05/29

⑥

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-05-29

⑥

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511 per kneeMOG/05/29

⑥

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MOG/05/29

6

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DL 06/05/29 ⑥

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27194

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 206/05/29 (4)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 206/05/29 (4)

14.0

DC

DOCUMENT CONTROL



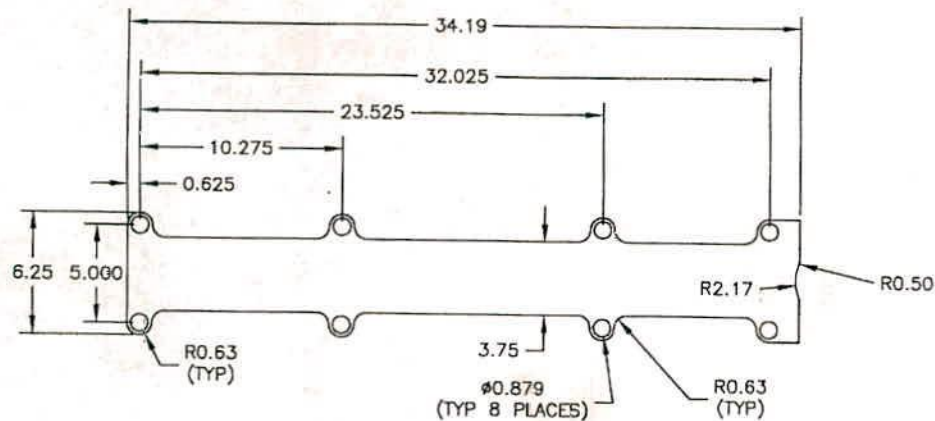
Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

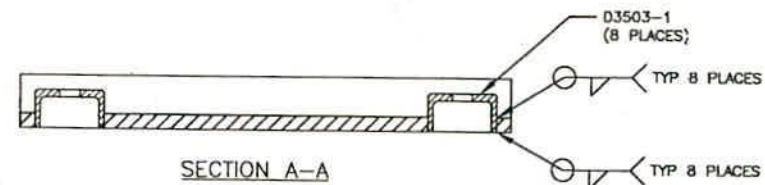
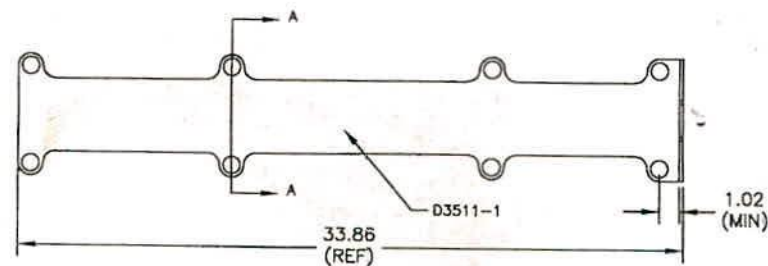


u Dec 5 29



D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



D3511-041 WELD DETAIL



D3511-1 BEND DETAIL

NOTE: BEND AFTER WELDING

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

RELEASED

06 04 25 #

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A	06.04.04	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3511
DATE	06.04.04	TITLE WEARPLATE
		REV. A SHEET 1 OF 1 SCALE NTS

NO. 27194
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOT COPY